

Date: Monday, 1/14/2008 2:37:07 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STRUT ASSEMBLY
Job Number	: 36749		
Estimate Number	: 10732		
P.O. Number	:	Part Number	: D23241
This Issue	: 1/14/2008 S.O. No. :	Drawing Number	: D2324 REV. C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1/1 Type : SMALL /MED FAB	Drawing Revision	: C
Previous Run	: 35930	Material	:
Written By	:	Due Date	: 2/20/2008 Qty: ²⁵ / ₂₀ Um: Each
Checked & Approved By	: <u>JOB 01/15</u>		
Comment	: Est: E 03.02.28 Reformat; Incorporated D2324-3 & D2324-5 KJ/RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	36749A	STOP
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B 34291A48



Comment: Sub-Component STOP

D2324-3 B 35930A 21

PC 8/01/06 (25)

2.0	36749B	STRAP
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Comment: Sub-Component STRAP

D2324-5 B 35930B

21

LO

B 36749B (29x)

3.0	AN312A	Bolt
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 40.0000 Each(s)

Bolt M10397

4.0	AN960JD10	Washer
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 80.0000 Each(s)

Washer M105792

5.0	MS21042L3	Nut
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 40.0000 Each(s)

Nut M105558

LO 8/01/16 25

6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D2324.

PC 8/01/16 (25)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: LD Date: 08/02/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/14/2008 2:37:08 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT ASSEMBLY

Job Number: 36749

Part Number: D23241

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/01/07 (25)

8.0

POWDER COATING

POWDER COATING



M1106379



(25X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M-1 08/02/01

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(25)

Comment: INSPECT POWDER COAT

08-02-04

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: 203

8/2/06 SC (25X)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



(25)

Comment: FINAL INSPECTION/W/O RELEASE

2008/02/08

Job Completion



min 2008/2/07 (25)

V

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

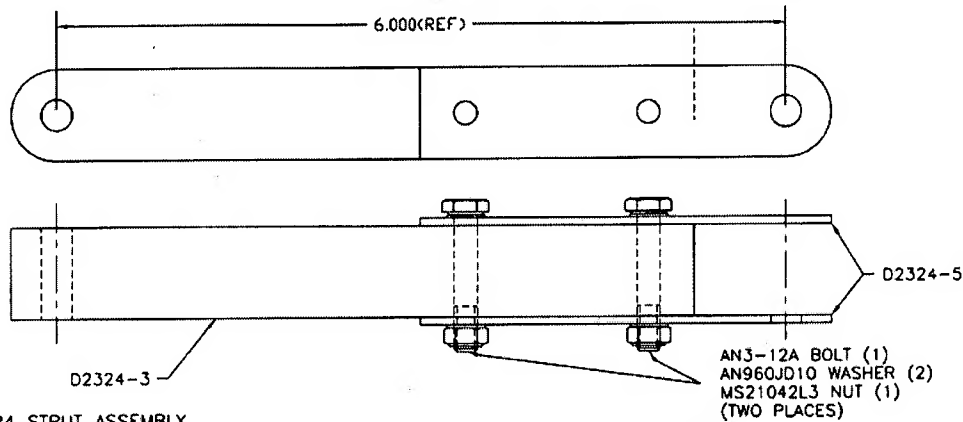
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



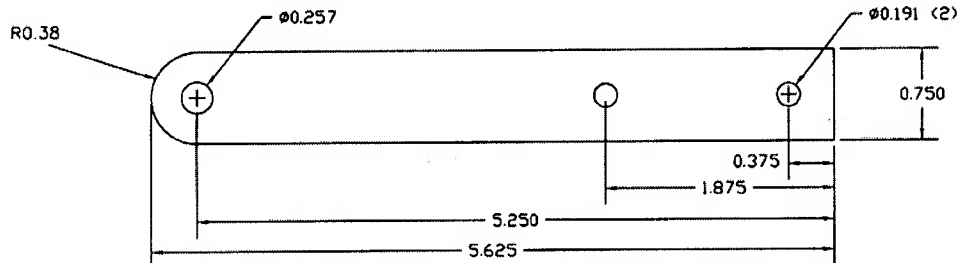
DESIGN B WILLIAMS	DRAWN BY PH	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2324	REV. C SHEET 1 OF 1
DATE 04.12.14	TITLE STRUT		
A	94.11.08	NEW ISSUE	
B	96.05.07	UPDATE MATERIALS	
C	04.12.14	UPDATE NOTES	

RELEASED
04.12.16 [Signature]



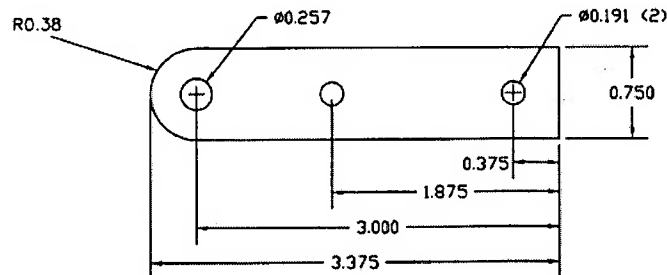
D2324 STRUT ASSEMBLY

- 1) IDENTIFY WITH DART P/N D2324 USING FINE POINT PERMANENT INK MARKER



D2324-3

- 1) MATERIAL: 6061-T6/T651-BAR (QQ-A-200/8)-0.75 X 0.75
(REF DART SPEC. M6061T6B0.750X00.750)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2324-5

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) FINISH: POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36749